

Date: Monday, 04/05/2009 1:44:41 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PANEL-W/O ROTOR BRAKE
Job Number	: 47669A		
Estimate Number	: 13583		
P.O. Number	:	Part Number	: D38211 GY
This Issue	: 04/05/2009 S.O. No. :	Drawing Number	: D38211
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : THERMOFORMING	Drawing Revision	: A
Previous Run	: 47332A	Material	: MKYD6185S080P362015
Written By	:	Due Date	: 11/05/2009 29 Qty: 1 Um: EACH
Checked & Approved By	: <u>JLD 09.05.09</u>		
Comment	: Est. A New Issue 08/09/17 DL		

Additional Product



Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MKYD6185S080P352068	6185 Kydex .080 steel grey 09/05/25
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Comment: Qty.: 13.2489 sf(s)/Unit Total: 13.2489 sf(s)
 6185 Kydex .080"

M 111807

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/05/21

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/05/22**x2**

4.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3821-1 and folio FTA 023 using tool DT 9053

Dwg. Rev. AFolio Rev. A**BB 09/05/22****x2**

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/05/22**x2**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 47669A.
Description:	Part Number: D38211
Inspection Dwg: D3821-1 Rev: A.	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radius less than _____" N/A				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/05/22

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.0"	MIN	1.62	✓			
.75"	MIN.	.81	✓			
0.63"	MIN.	.664	✓			
0.25"	MIN.	.301	✓			
0.375"	MIN.	.541	✓			
0.050"	MIN.	.063	✓			
0.020"	MIN.	.037	✓			

Measured by: BB

Date: 09/05/22

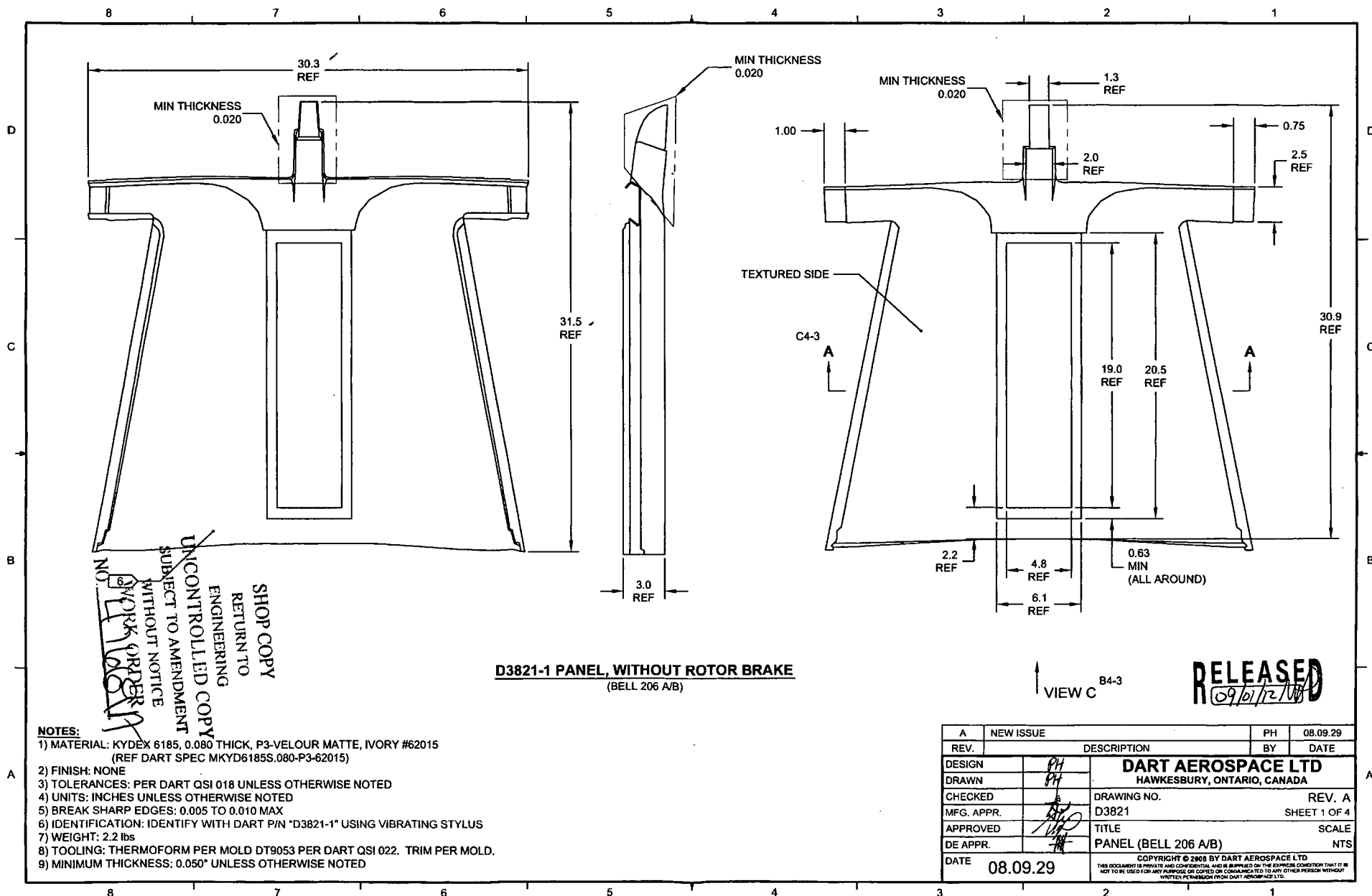
Audited by: [Signature]

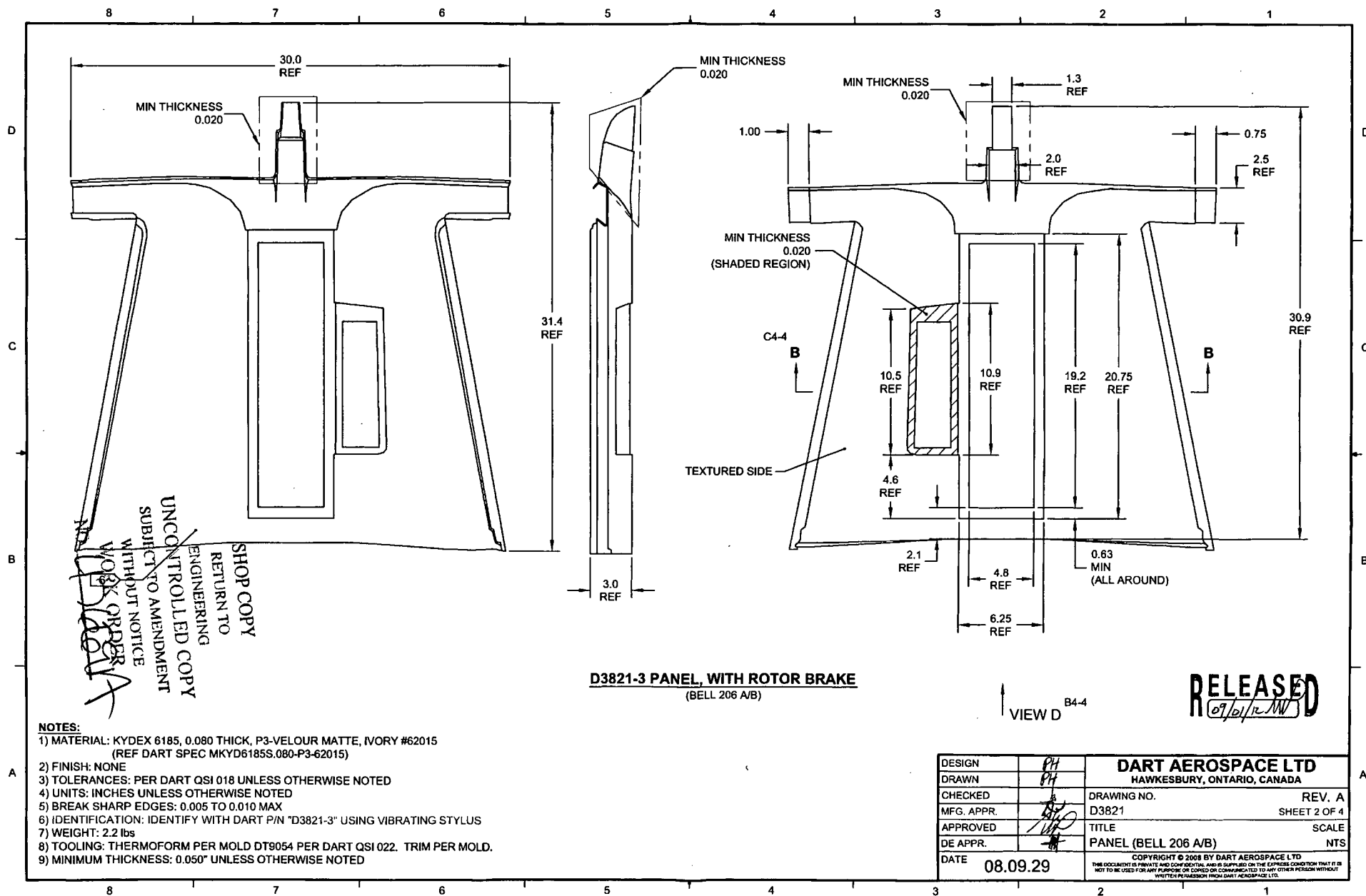
Date: 09/05/25

Prototype Approval:

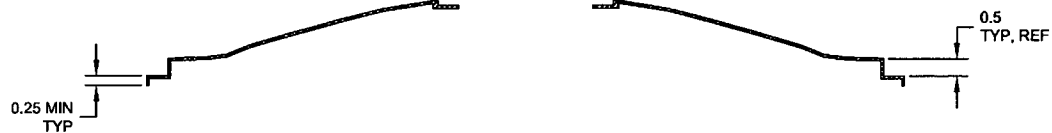
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

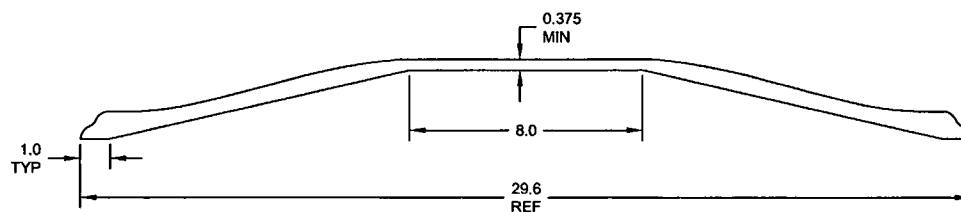




SECTION A-A C4-1



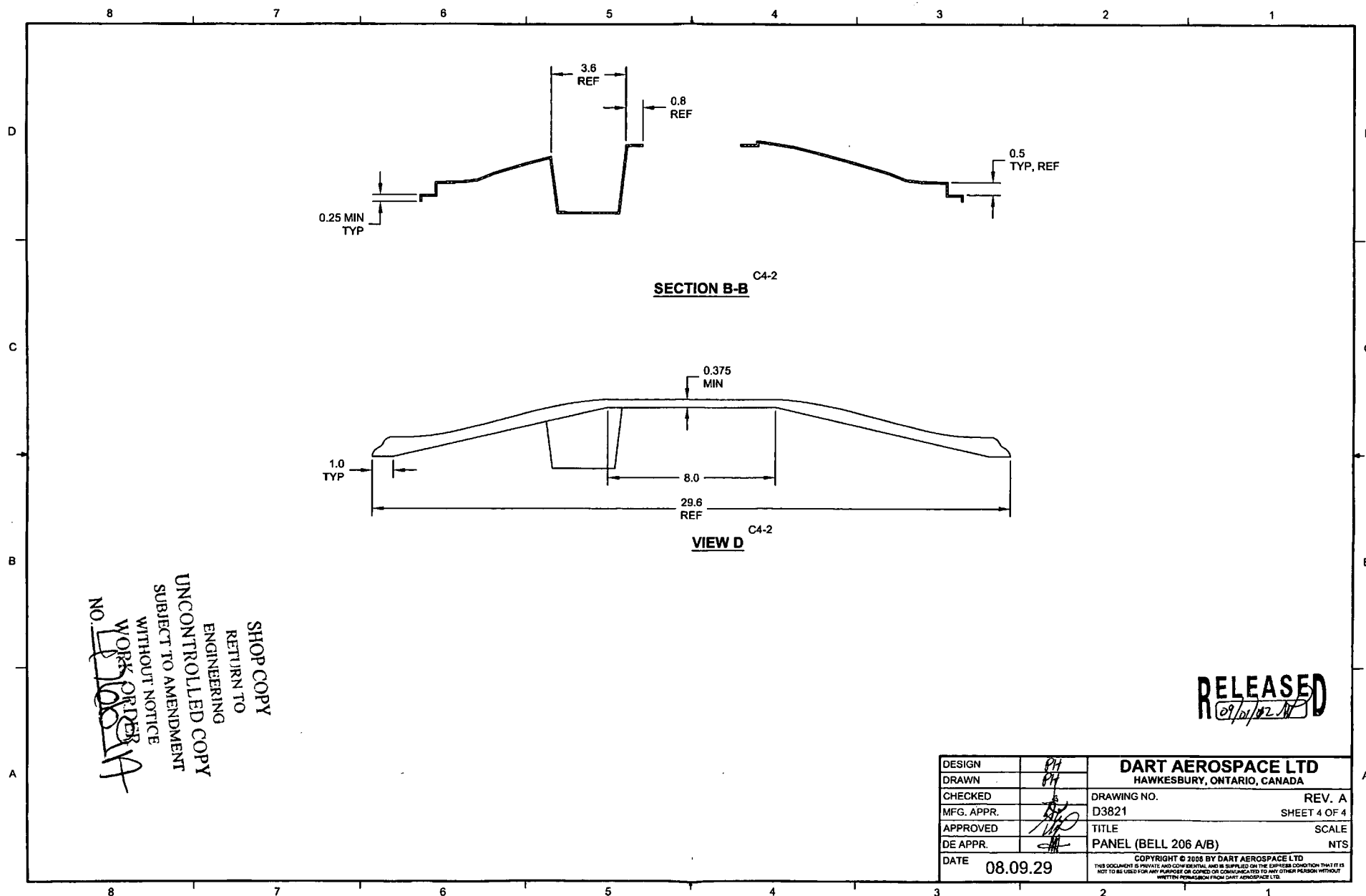
VIEW C A2-1

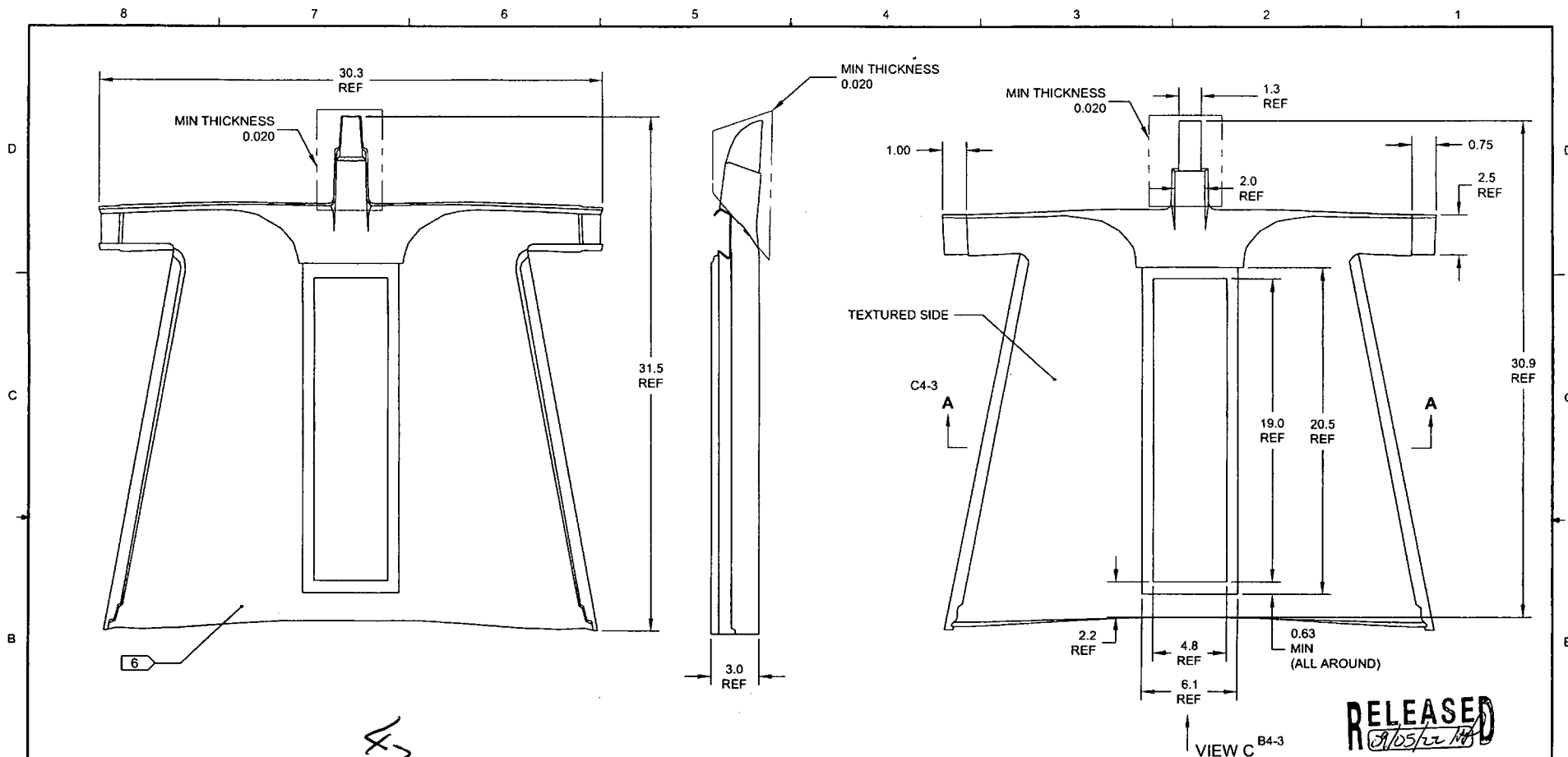


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RELEASED
09/01/12

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3821	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		PANEL (BELL 206 A/B)	NTS
DATE	08.09.29	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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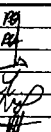


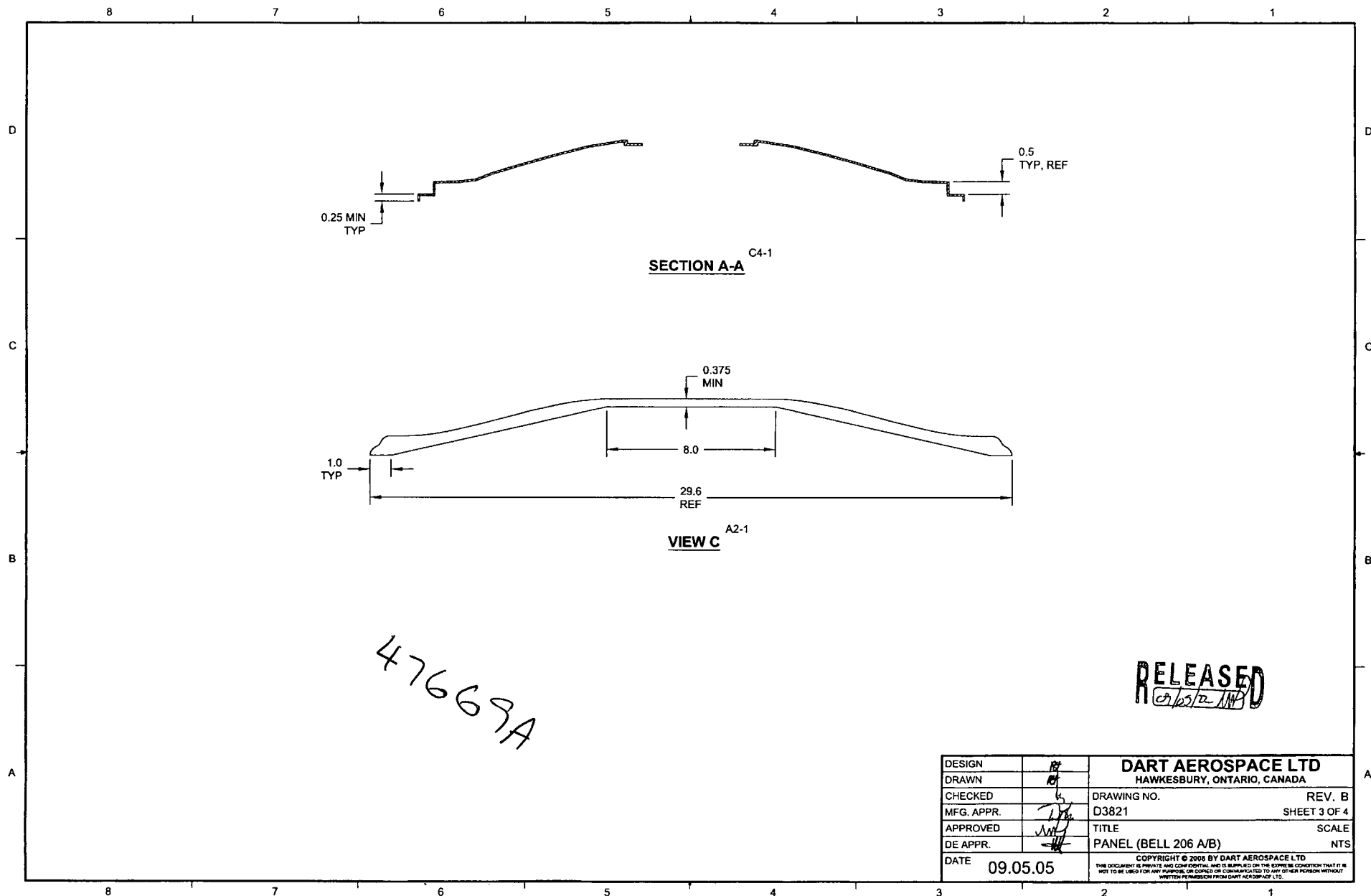
D3821-1 PANEL, WITHOUT ROTOR BRAKE
(BELL 206 A/B)

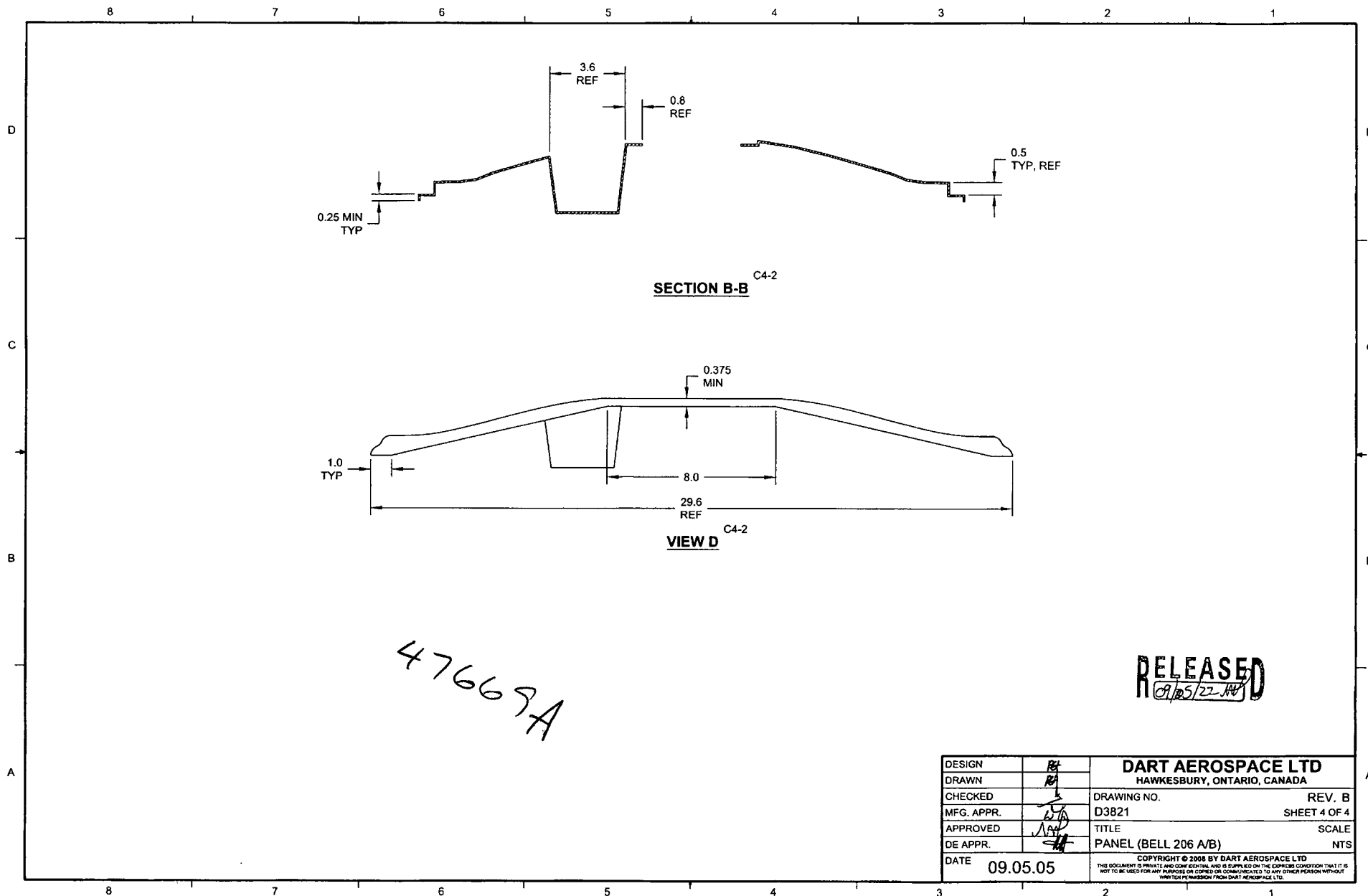
NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 2.2 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9053 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050* UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3821-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3821-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

B	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N'S D3821-1KIV, D3821-3KIV AND ADD STEEL GRAY P/N'S D3821-1KGY, D3821-3KGY (ZN A5-1, A5-2)	PH	09.05.05
A	NEW ISSUE	PH	08.09.29
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		REV. E	
CHECKED		DRAWING NO.	SHEET 1 OF 4
MFG. APPR.		D3821	
APPROVED		TITLE	SCALE
DE APPR.		PANEL (BELL 206 A/B)	NTS
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DRAWN	RA		
CHECKED	J	DRAWING NO.	REV. B
MFG. APPR.	6/10	D3821	SHEET 4 OF 4
APPROVED	RAY	TITLE	SCALE
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